

Date: Tuesday, 3/11/2008 7:57:37 AM  
 User: Kim Johnston

## Process Sheet

875 08/03/24  
 Split u/o

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARING ASSEMBLY  
 Job Number : 37750 -1  
 Estimate Number : 10716  
 P.O. Number :  
 This Issue : 3/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3121241  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D3121 REV E  
 Previous Run : 37475 Drawing Revision : E  
 Written By :  
 Checked & Approved By : AG 08 03 11 Material :  
 Comment : Est Rev: A 04.02.18 New issue KJ/DS Due Date : 3/31/2008 Qty: 39 Um: Each  
 Est Rev: B ECN 1060 07-11-12 DD verified by: EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRIINR12500 DELRIN ROUND BAR 1.25"



Comment: Qty.: 0.0546 f(s)/Unit Total: 2.1840 f(s)

Material: Ø1.25 Delrin Rod

(M-DELRIN-R1.2500) Identify as D3121-25

Batch: M104398

J.F. 08/03/24

(48)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

J.F. 08/03/23

(48)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/03/23

(48)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08.03.25

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-23 Bearing B37880

875 08/03/24

uesday, 3/11/2008 7:57:37 AM

Kim Johnston

# Process Sheet

Drawing Name: BEARING ASSEMBLY

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D3121241

Job Number: 37750

Job Number:



Description :

Seq. #:

Machine Or Operation:

SMALL & MEDIUM FAB RESOURCE 1

6.0

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

*ml 08/03/24 x39*

7.0

QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1

8.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57-38*

FINAL INSPECTION/W/O RELEASE

9.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



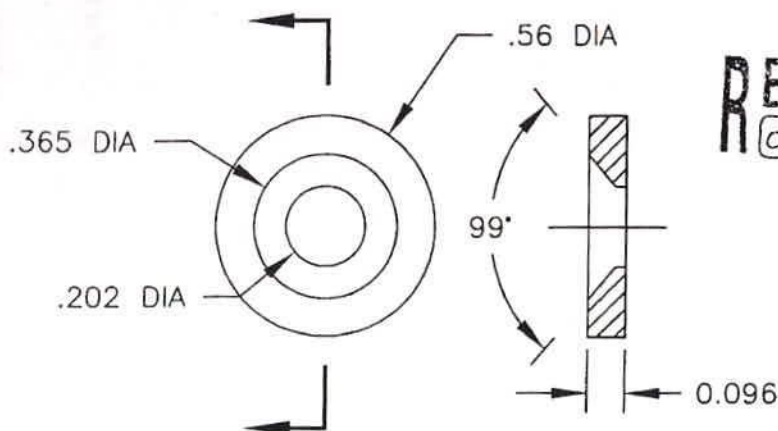
*u 08-03-24*



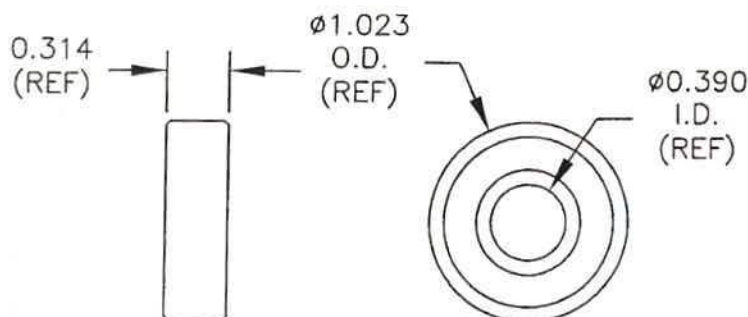


**DART**

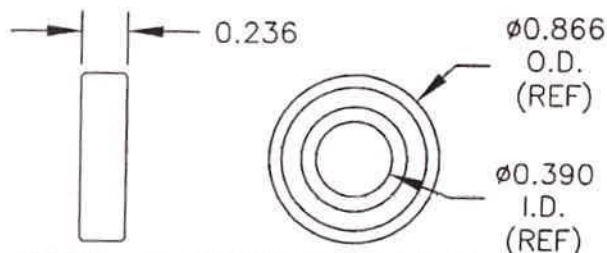
DESIGN <i>[Signature]</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

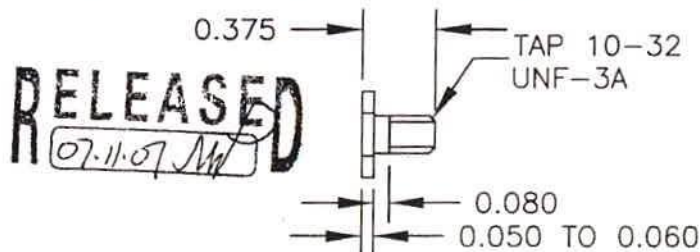
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

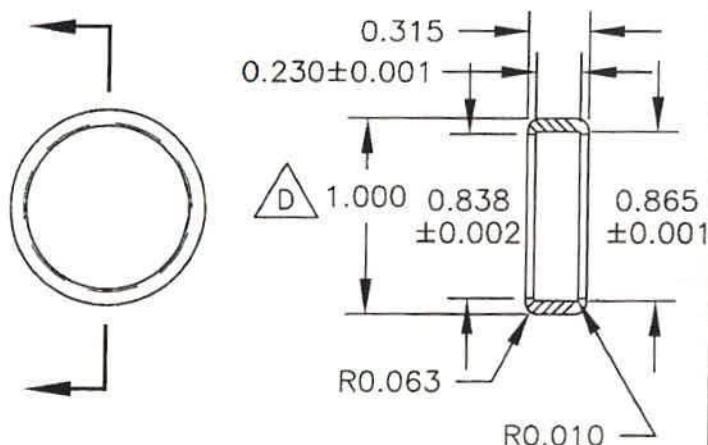
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

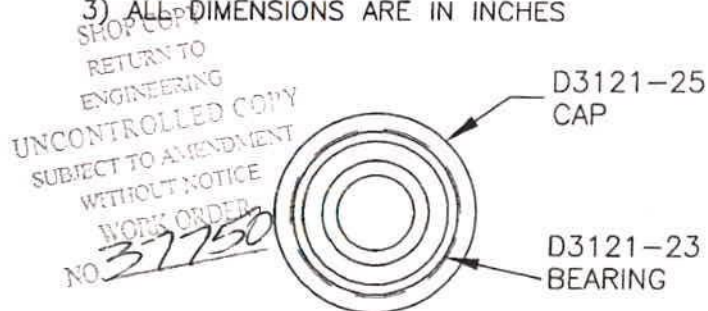
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD,  $\phi 1.25$  (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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